

Work Order ID 160187

Friday, April 21, 2017 5:53:42 PM

160187

Page 1

Item ID: 646.3314 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Blade
Start Date: 4/25/2017 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 5/22/2017 Req'd Qty: 8.00 ***8*** Customer:
Reference: (P.A.)SCHEDULED/S

Approvals: Process Plan: 21 Date: APR 24 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
646.3300	N/C3								

100

100

Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut Blank at 5.050"

0.00

0.29

8

Ø

DAS
20
9-89

17-04-21

110

110

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine per folio FB147

DWG REV: N/CFOLIO REV: 11

0.53

3.60

8

Ø

DAS
20
9-89

17-04-26

2- deburr and break all sharp edges except otherwise noted

KNIFE EDGE MUST BE SHARPENED USING STONE, REMOVE ALL
BURRS ON CUTTING EDGE

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER : ☐							

DQA: _____ Date: _____



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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Receive & Inspect for Damage & Mat'l Certs	0.00							
150									
Packaging	Memo	0.16							
Packaging									
155	QC5- Inspect part completeness to step on W/O	0.00							
155									
QC	Memo	0.16							
Quality Control									
160	Spray Painting per QSI005 4.2	0.00							
160									
SprayPaint	Memo	0.24							
Spray Painting	PRIME AS PER DWG, SEE NOTE #4								
	PRIMER BATCH: <u>137287</u>								

8XSP17-5-23

DAS 38 9-89
MAY 23 2017

DAS 41 9-89
MAY 31 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC14- Inspect Spray Paint	0.00				3			DAS 38 9-89 JUN 02 2017
170	Memo	0.00							
QC									
Quality Control									
180	Identify as per dwg & Stock Location: CK103	0.00				8			DAS 6 9-89 JUN 02 2017
180	Memo	0.08							
Packaging									
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***								
190	QC21- Final Inspection - Work Order Release	0.00							17/6/7 JG
190	Memo	0.80							
QC									
Quality Control									

JUN 02 2017

DQA: _____ Date: _____



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Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process	OTHER : _____							
Misidentified ☐	☐	Past Due								

Picklist Print

Friday, April 21, 2017 5:53:42 PM

Page 1

Work Order ID: 160187

160187

Parent Item: 646.3314

646.3314

Parent Item Name: Blade

Start Date: 4/25/2017

Required Date: 5/22/2017

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A NEW ISSUE 12/11/07 JFS VERIFY BY: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MSTEEL-A2- B0.500X1.250		Purchased		No		100	f	35.9700	0.421	3.545263			

MSTEEL-A2-B0 500X1 250

AISI A2 TOOL STEEL BAR, 0.500 X 1.250

**

3.470'

DAS

20

9-89

17-04-21

Location

Loc Qty

Loc Code

MAT010

35.97

M136847

11.97

M137285

24

0.490'

2.980'

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER : _____							

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO.

04765

SHEET 1 OF 1

DWG NO. 646.3300

REV: NC

PREPARED BY J. SOTO

DATE: 12/08/2014

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: UPPER CUTTER ASSY

APPROVED BY: ENGR. 

MFC Dwight Baker

QC

EFF. NEXT ORDER

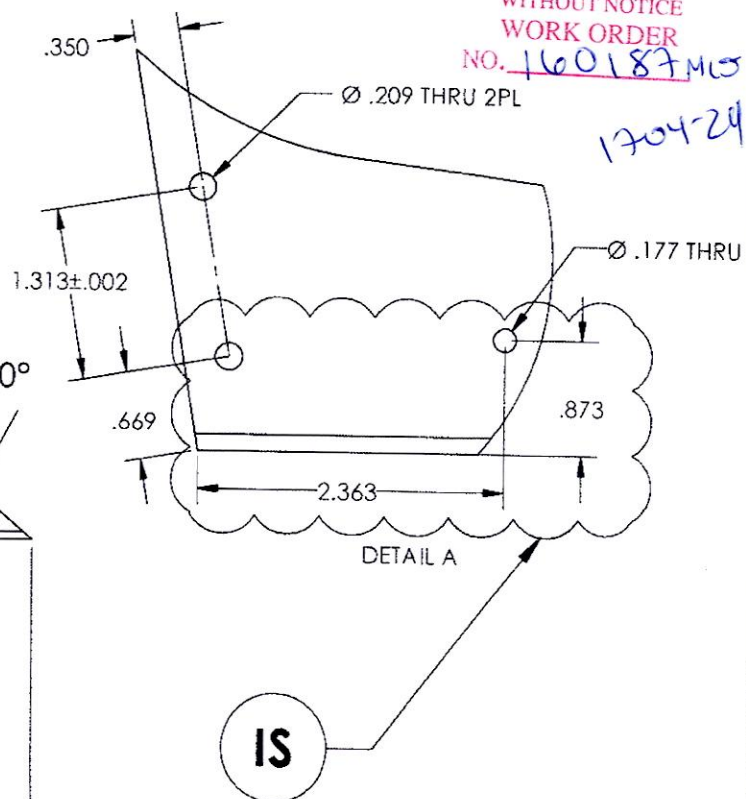
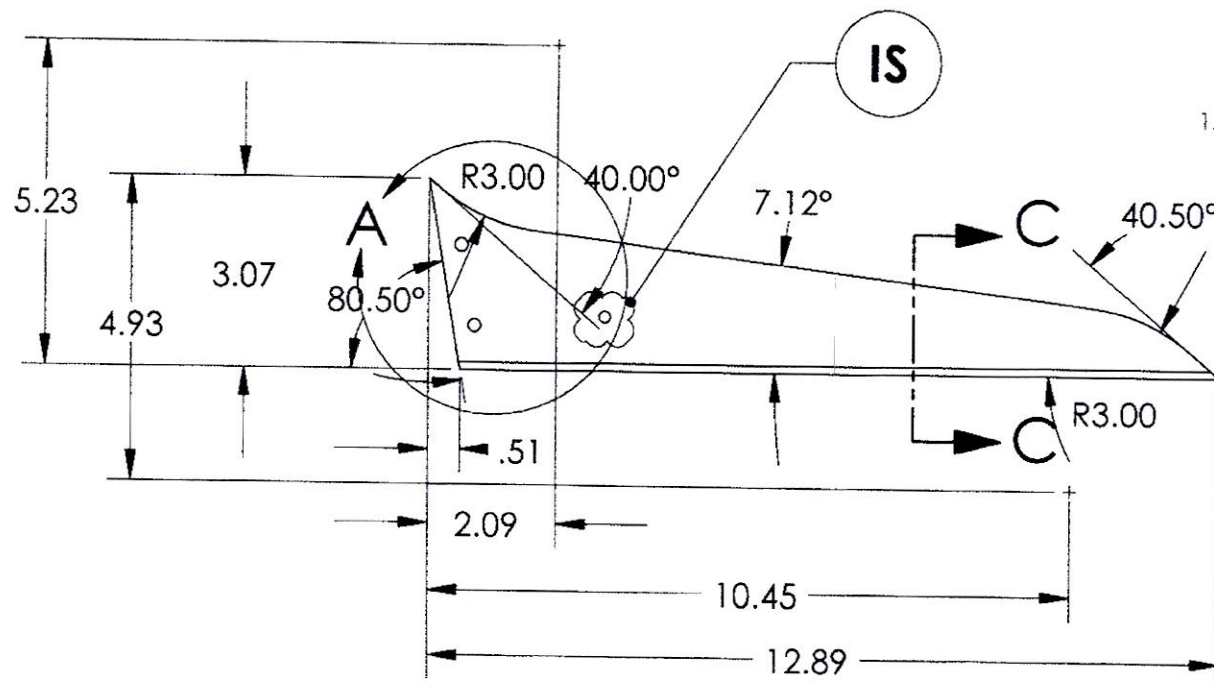
TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON: ADDED HOLE DIMENSION TO 646.3313.

SHEET 5 IS:

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 160187 MJS

1704-20



DOCUMENTS EFFECTED:

☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM

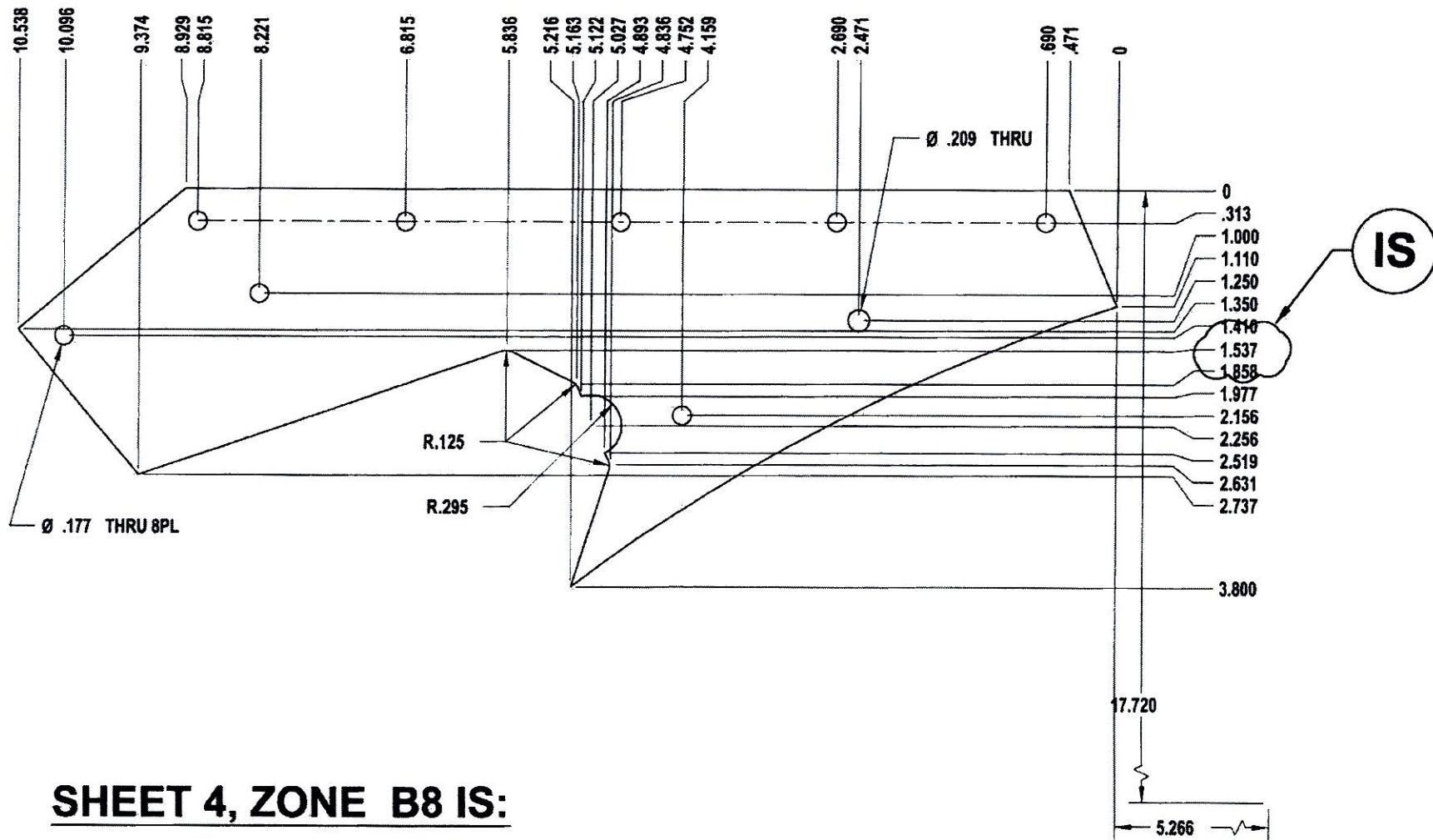
CHANGE CATEGORY

☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED

☐ YES ☒ NO

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03724				SHEET 1 OF 1	
	DWG NO. 646.3300	REV: N/C	PREPARED BY B. PETERS	DATE: 12/05/12	EFFECT ON DWG ☐ INC. ☒ UNINC.	
	DWG TITLE: UPPER CUTTER ASSY					
	APPROVED BY: ENGR <i>[Signature]</i>	MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: NEXT ORDER		
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON: REVISED ORDINATE DIMENSION.				ECR: D-12-025	

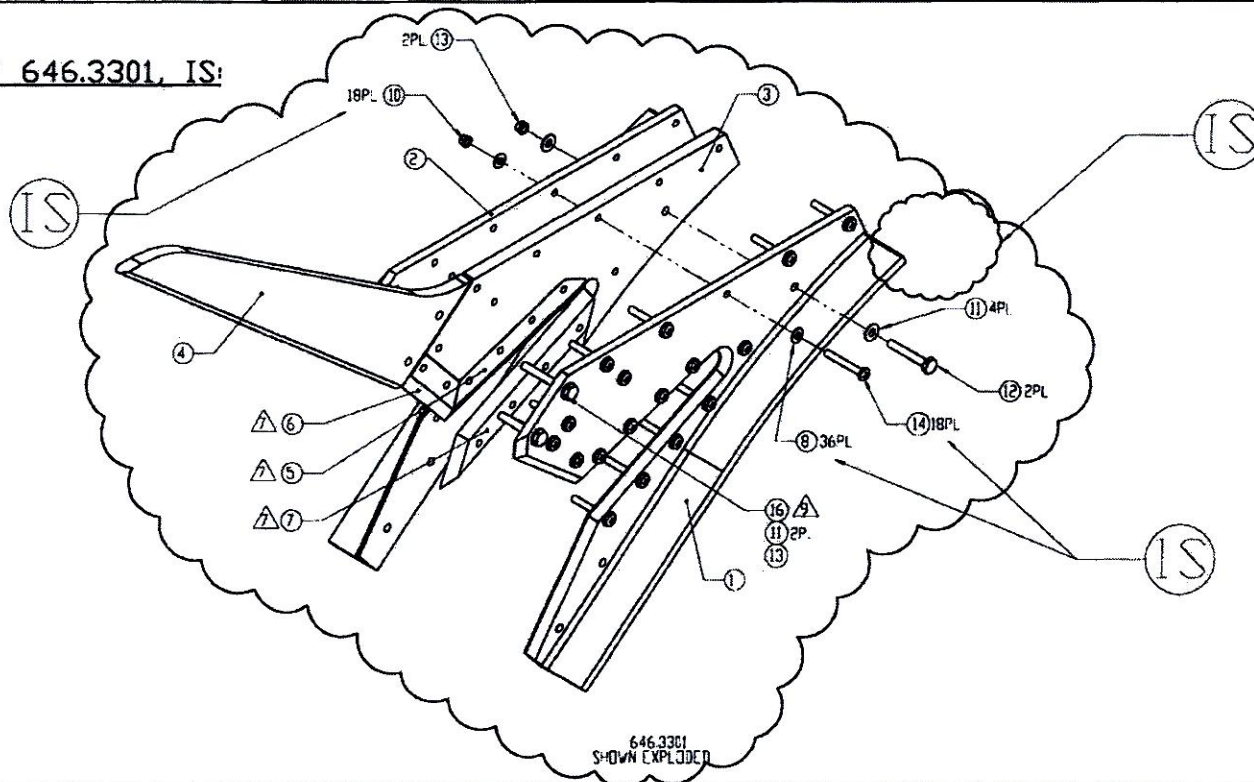


SHEET 4, ZONE B8 IS:

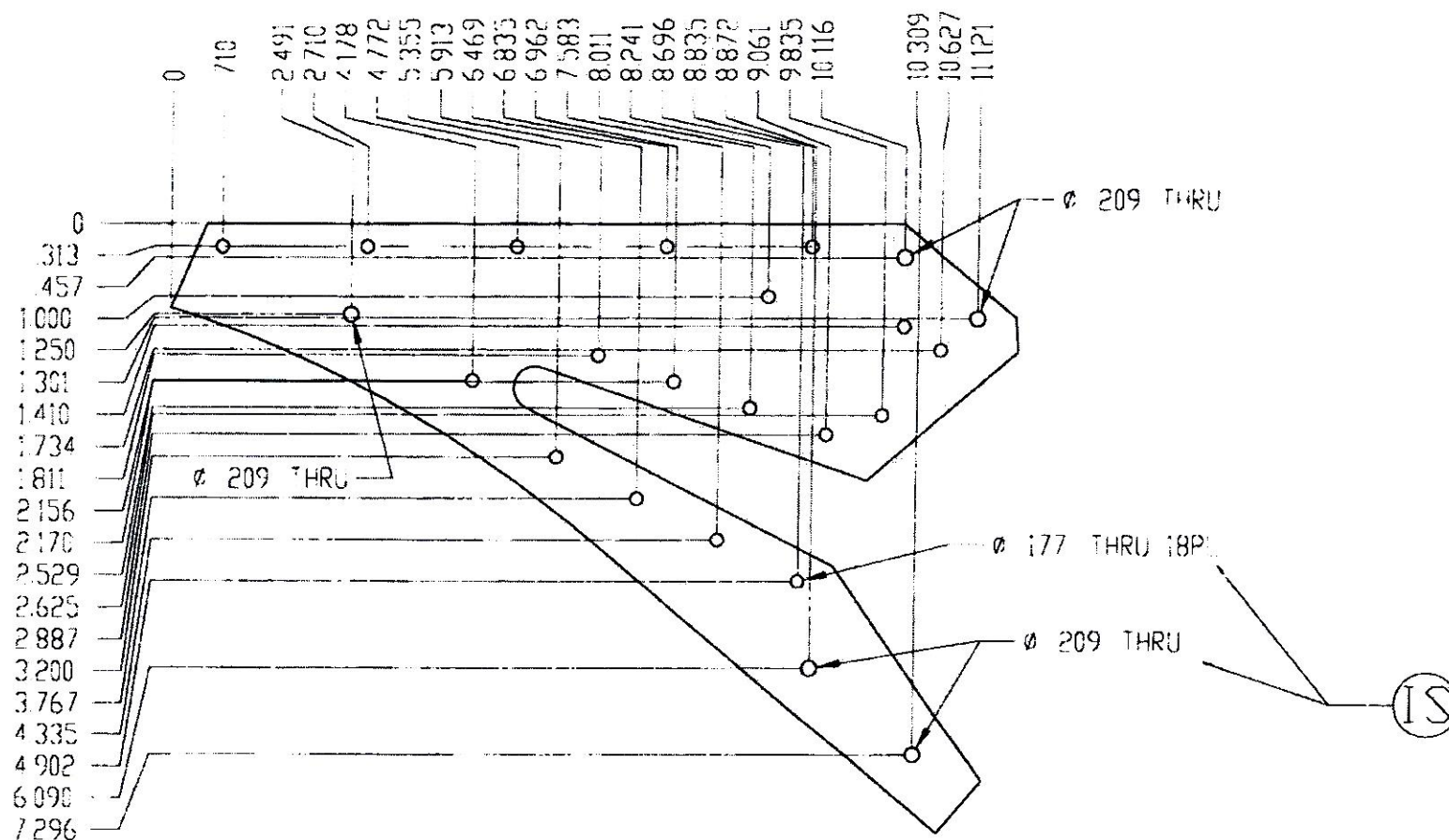
DOCUMENTS EFFECTED:	☐ RFMS ☐ MDL ☐ INSTALL INSTRU ☐ ICA ☐ BOM	CHANGE CATEGORY ☐ MAJOR ☒ MINOR	DER REVIEW REQUIRED ☐ YES ☒ NO
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APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 02196		SHEET 1 OF 2	
	DWG NO. 646.3300	REV: N/C	PREPARED BY S. HUFF	DATE: 01/05/09
	EFFECT ON DWG ☐ INC. ☒ UNINC.			
DWG TITLE: UPPER CUTTER ASSY				
APPROVED BY: ENGR <i>[Signature]</i>	MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: NEXT ORDER	
REASON: REMOVED RIVETS IN FAVOR OF ADDITIONAL SCREWS				
TRANSACTION CODES (TC) A-ADD C-CREATE R-REVISE D-DELETE				

SHEET 1, VIEW 646.3301, IS:

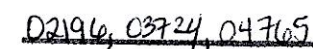


14	R	601.2765	18	SCREW	MS27039-0819
10	R	601.1541	18	LOCKNUT	MS21042L08
9	D	601.2766	3	RIVET	MS20470AD5-18
8	R	601.2764	36	WASHER	NAS1149FN832P
			.3301		
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION
DOCUMENTS EFFECTED:					CHANGE CATEGORY
☐ MDL ☒ INSTALL INSTRU ☒ ICA ☐ FMS ☒ BOM					☐ MAJOR ☒ MINOR
DER REVIEW REQUIRED					☐ YES ☒ NO

SHEET 3. SECTION VIEW A-A, IS:

F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION

EXPENSE			
REV	DESCRIPTION	DATE	APPROVED

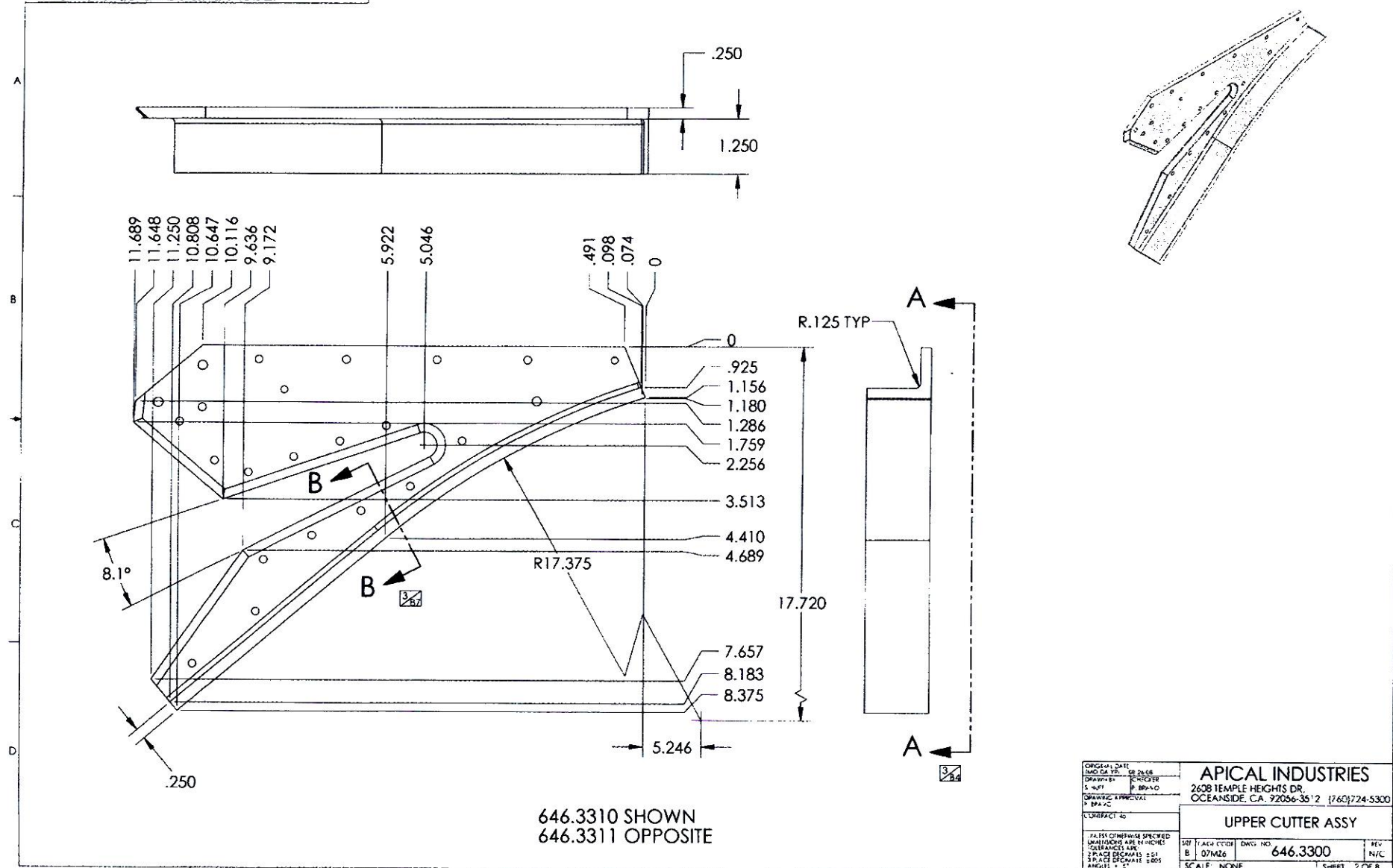


- ① MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12
- ② FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2. COLOR BLACK;
CARDINAL 4860-50 PRETREATMENT PRIMER
PRIME IAW MIL-P-23377J TYPE I CLASS N
- ③ MATERIAL: AISI A2 TOOL STEEL
CONDITION: ANNEALED
POST PROCESS: HEAT TREAT TO 58-62 Rc ROCKWELL HARDNESS
- ④ FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N
5. DEBURR AND BREAK ALL SHARP EDGES EXCEPT WHERE OTHERWISE NOTED
6. IDENTIFY IAW MPP 120
- ⑦ APPLY F/N 15 AS REQUIRED TO ALL FAYING SURFACES OF F/N 5, 6 & 7 UPON ASSEMBLY
- ⑧ CUTTING EDGE INTENDED TO BE SHARP. DO NOT BREAK SHARP EDGE
- ⑨ INSTALL FASTENER FINGER-TIGHT

646.3301
SHOWN EXPLODED

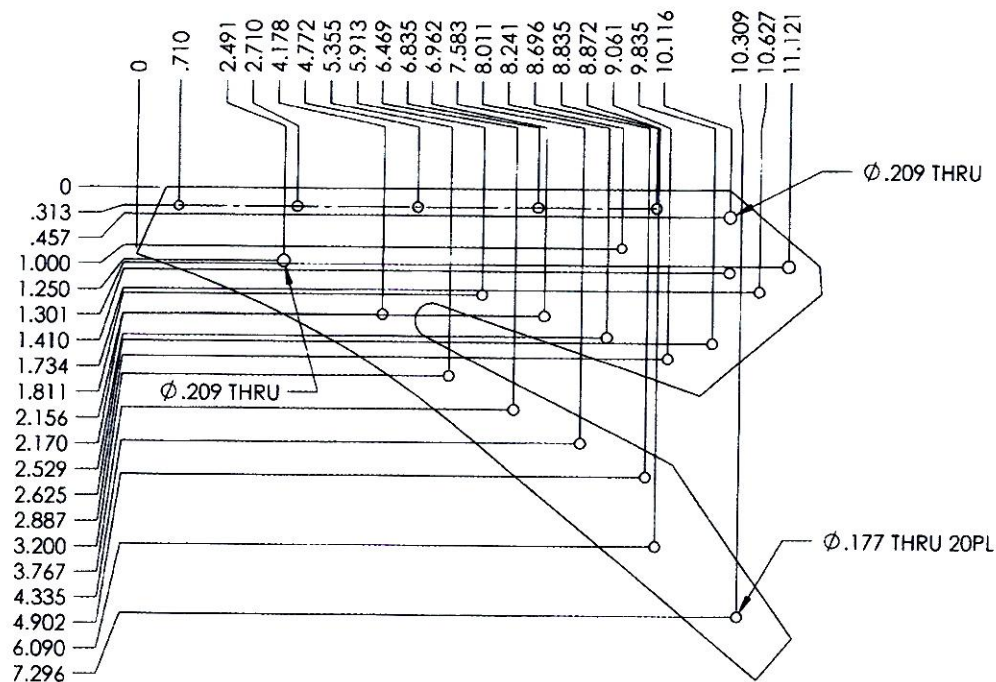
[illegible]

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ORIGINAL DATE: 10/01/01 DRAWN BY: S. WYATT CHECKED BY: P. BRADY DIMENSIONS: 1/8" DIA. C. CONTRACT 40				APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1. PLACE DIMENSIONS ± .01 2. PLACE DIMENSIONS ± .005 ANGLES: 1°				UPPER CUTTER ASSY			
REV.	DATE	BY	NO.	REV.	DATE	BY	NO.
B	07/02/06			N/C			
SCALE: NONE				SHEET 2 OF 8			

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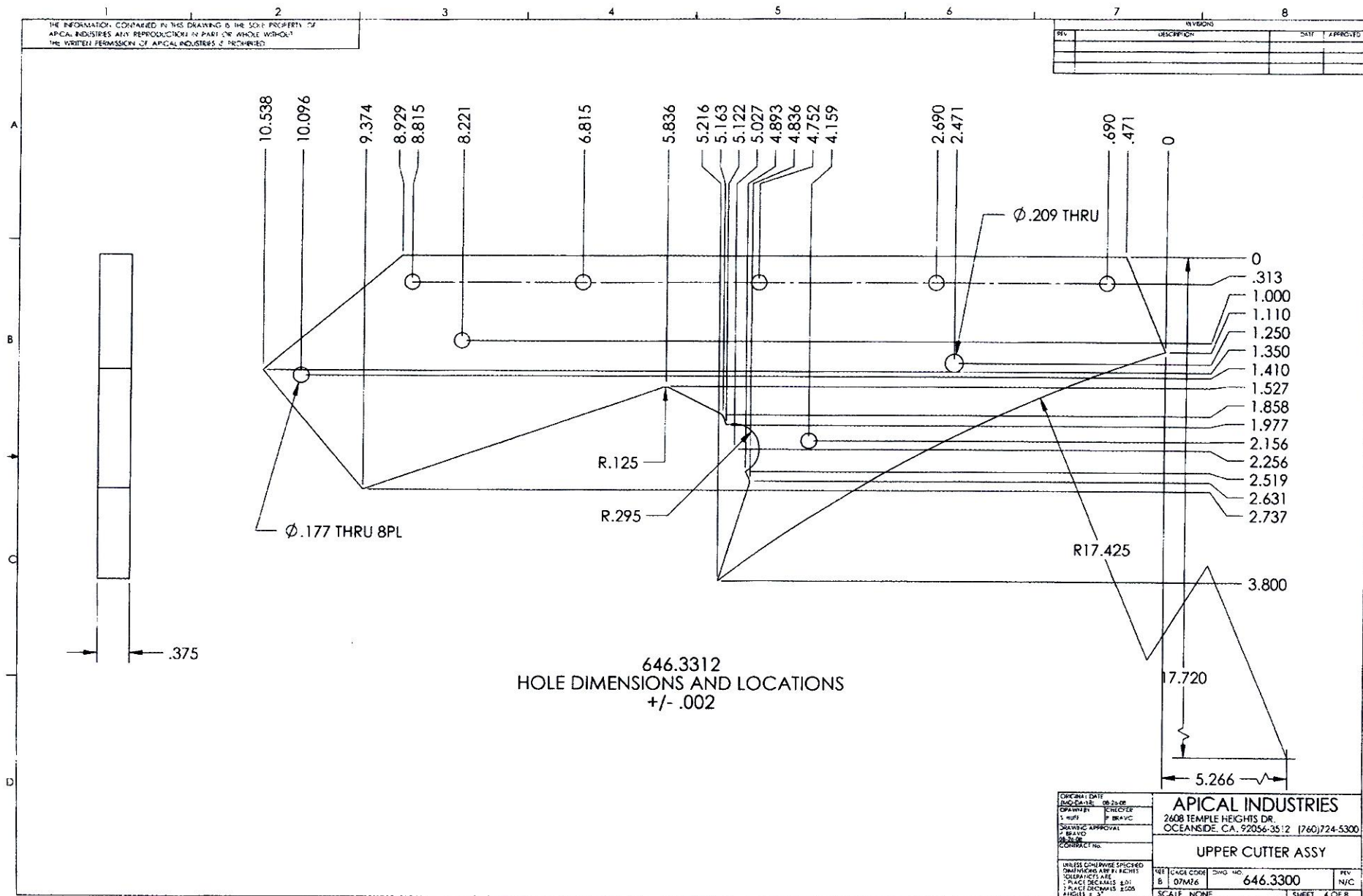
SECTION A-A

SECTION B-B

ORIGINAL DATE 10/20/00		APICAL INDUSTRIES	
DRAWN BY: J. HUI		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056 3512 (760) 724 5300	
CHECKED BY: J. HUI		UPPER CUTTER ASSY	
APPROVED BY: J. HUI		SCALE: NONE	
COMPANY NO.		SHEET 3 OF 8	
ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED ARE IN INCHES		REV. NO.	
TOLERANCES ARE:		646.3300	
1. FRACTIONS .005		N/C	
2. DECIMALS .005			
3. PLACES DECIMALS .005			

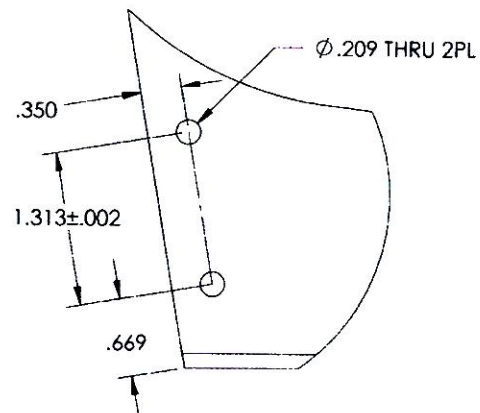
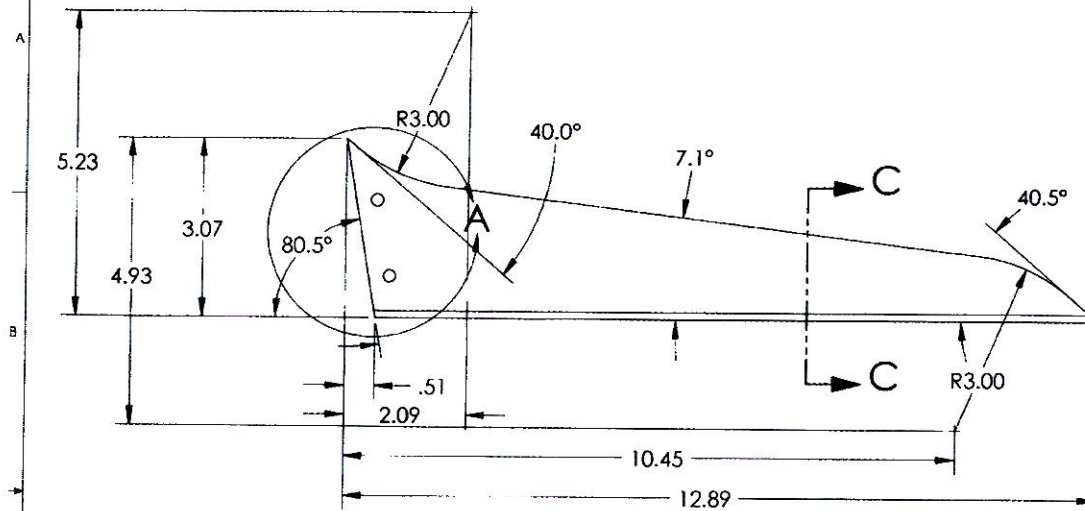
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REV.	DESCRIPTION	DATE	APPROVED

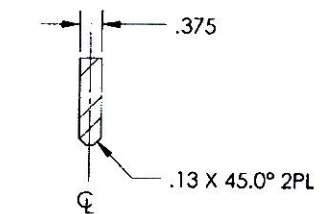


ORIGINAL DATE DRAWN BY CHECKED BY DESIGNED BY APPROVED BY CONTRACT NO.	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300 APICAL INDUSTRIES UPPER CUTTER ASSY
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1. FRACTIONS .005 2. DECIMALS .01 3. ANGLES .5°	SHEET NO. 4 OF 8 SCALE NONE PART NO. 646.3300 REV. N/C

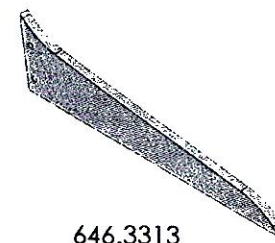
FEV/GONG			
REF	DISCRIPTION	DATE	APPROVED



DETAIL A



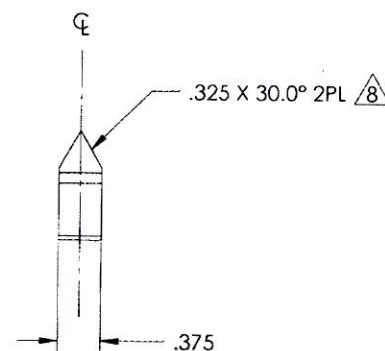
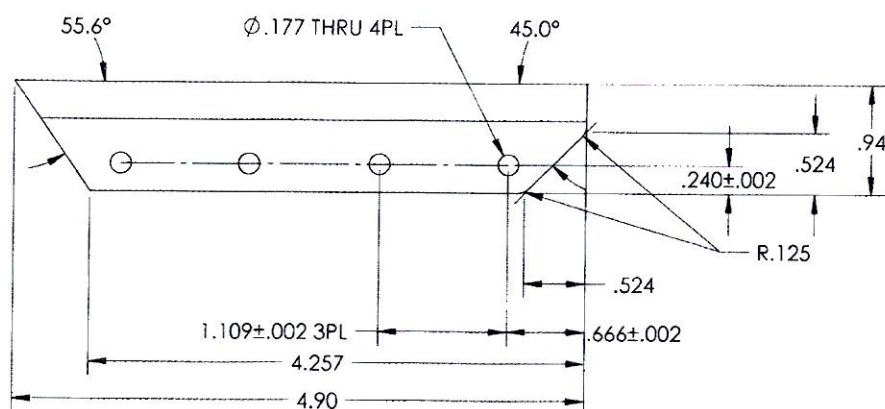
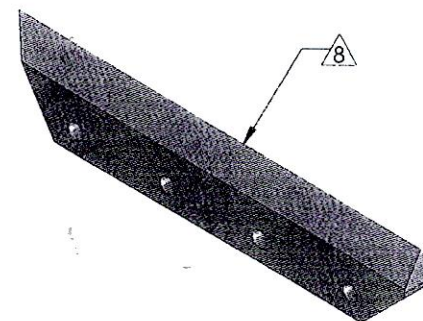
SECTION C-C



646.3313

[illegible]

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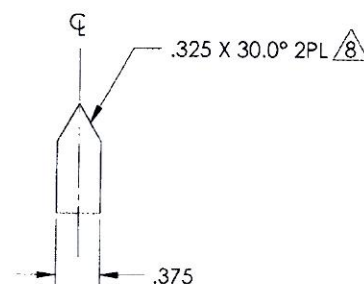
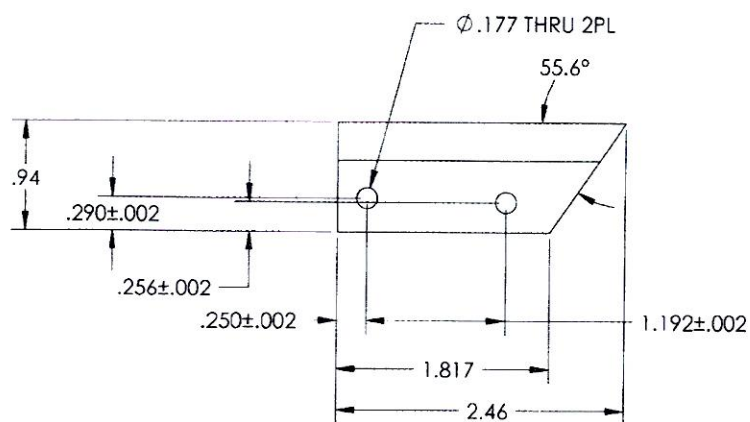
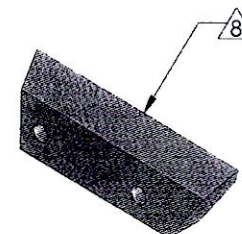
[illegible]

646.3314

ORIGINAL DATE	APICAL INDUSTRIES		
NO. (DO NOT WRITE)	2608 TEMPLE HEIGHTS DR.		
DATE OF ORDER	OCEANSIDE, CA 92066-3512 (760) 724-5300		
QUANTITY	UPPER CUTTER ASSY		
PRICE PER UNIT	646.3300		
TOTAL	SCALE NONE		
DATE	SHEET 4 OF 4		

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED

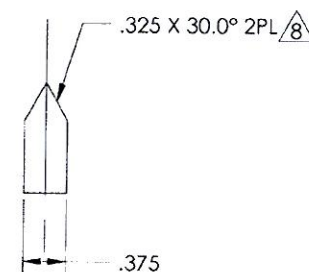
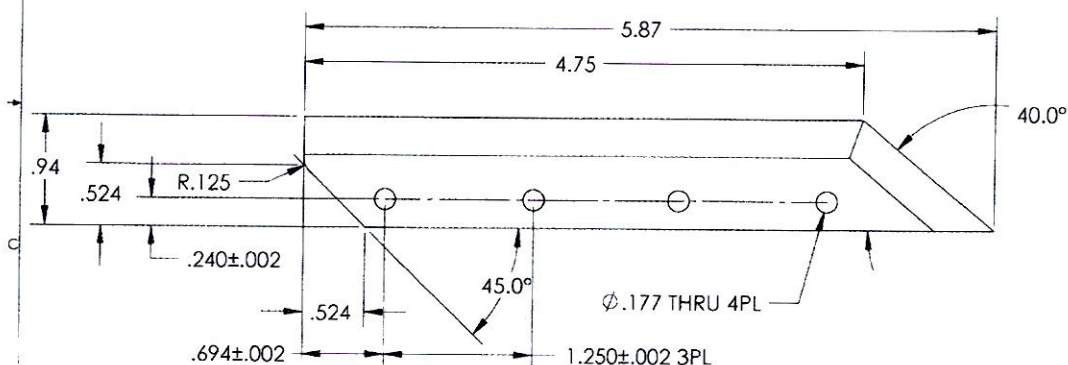
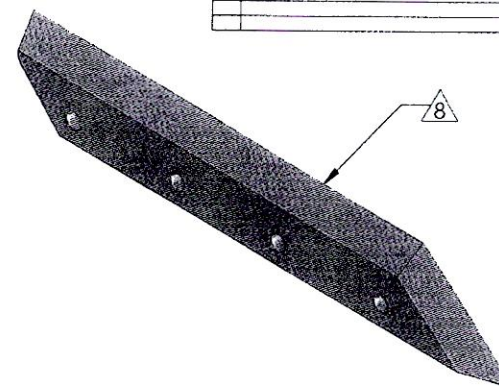


646.3315

ORIGINAL DATE 1/10/11		BY: JAC	
DRAWN BY: S. MUIH		CHECKED BY: P. BRAVO	
DRAWING APPROVAL		DATE: 1/10/11	
CONTRACT NO.		SCALE: NONE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		REV. NO. 8	REV. N/C
APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300		SHEET 7 OF 8	

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REV	DESCRIPTION	DATE	APPROVED



646.3316

ORIGINAL DATE UNMODIFIED 08-26-08	APICAL INDUSTRIES	
DRAWN BY: J. HUI CHECKED: J. BRAVO DRAWING APPROVAL: DATE: 08-26-08 DESCRIPTION:	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
CONFIRMED DATE	UPPER CUTTER ASSY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1. PLACE DECIMALS ±.01 2. PLACE DECIMALS ±.005 3. PLACE DECIMALS ±.0025 ANGLES ±.5°	REV N/C	
SHEET 8 OF 8	SHEET 8 OF 8	SHEET 8 OF 8



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO36164**

Purchase Order Date 5/2/2017
PO Print Date 5/17/2017

Page Number 2 of 3

Order From :
METCOR INC.
560 BOUL. ARTHUR SAUVE
SAINT-EUSTACHE, QC J7R 5A8
CA

VC-MET004

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 450 473 1884

Ship To Contact
Ship To Phone
Ship Via: FedEx Economy collect
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA – (Free Carrier)

				Line Total:	\$48.08
3	160187	646.3314 BLADE	5/18/2017 Yes 5/18/2017	8.00	\$4.81
					\$38.46
FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS					
PART ARE MADE FROM AISI A2 TOOL STEEL					
PLEASE NOTE: DETAIL C OF C REQUIRED					
				Line Total:	\$38.46
4	160073	646.3315 BLADE	5/18/2017 Yes 5/18/2017	12.00	\$4.81
					\$57.69
FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS					
PART ARE MADE FROM AISI A2 TOOL STEEL					
PLEASE NOTE: DETAIL C OF C REQUIRED					
				Line Total:	\$57.69

Note:

5/17/2017

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL Order	EXPÉDITEUR Shipper ID	BON D'EXPÉDITION Shipper
318924	1	119512

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

DART AEROSPACE

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



LIVRÉ À /Shipped To

DART AEROSPACE

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipper No.	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
36164		A2	2017/5/3	MINIMAX 1/2

QUANTITÉ Quantity	No. PIÈCE Part No.	NOM DE LA PIÈCE Part Name	DESCRIPTION DE LA PIÈCE Part Description	POIDS Weight
----------------------	-----------------------	------------------------------	---	-----------------

52 646.3015

17,

✓ (10) 646.3015 160180

✓ (10) 646.3015 158880

✓ (8) 646.3314 160187

✓ (12) 646.3315 160073

✓ (12) 646.3316 160072

1 VALISE

8017-5-23

TYPE DE CONTENEUR Container Type	# DE CONTENEURS # Of Containers	COMMENTAIRES CONTENEUR Container Comments
VALISE	1	

CERTIFICAT

EMPAQUETAGE Packing	
------------------------	--

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 52

POIDS EXPÉDIÉ / Weight Shipped : 17,00

QUANTITÉ RESTANTE / Quantity Remaining : 0

POIDS RESTANT / Weight Remaining : 0,00

CERTIFICAT

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 52

POIDS EXPÉDIÉ / Weight Shipped : 17,00

Signature:

Date:

EXPÉDIÉ LE / Shipped On : 2017/05/16

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
318924	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
36184	N/A	A2		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

VAC HARDEN

HARDEN AND TEMPER

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	58 - 62 HRC	5	60 - 62 HRC

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
52	17	646.3015 (10) 646.3015 160180 (10) 646.3015 158880 (8) 646.3314 160187 (12) 646.3315 160073 (12) 646.3316 160072 1 VALISE

SP17-5-23

16 mm

COMMENTAIRES / comments

APPROUVÉ par / Approved by:



DATE: 2017-05-16

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détail

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
318924	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
36164	N/A	A2		
SPECIFICATIONS DU PROCÉDÉ processing specifications				
VAC HARDEN				
HARDEN AND TEMPER				
EXIGENCE / requirement	SPECIFICATIONS / specified		TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	58 - 62 HRC		5	60 - 62 HRC
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
52	17	646.3015 (10) 646.3015 160180 (10) 646.3015 158880 (8) 646.3314 160187 (12) 646.3315 160073 (12) 646.3316 160072 1 VALISE		

COMMENTAIRES / comments

VAC HARDEN 1800F, 1:30 HR
TEMPER 400F, 2 HRS

Heat treatment (HT) was performed with equipment that meets the requirements of AMS2759 & AMS2750. All HT operations were in compliance with AMS2759 and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with AMS2759 and the purchase order and was found to meet the requirements. This document and any attached documents may contain confidential or proprietary information and may be subject to export control laws and regulations. If you are not the intended recipient, you are notified that any dissemination, copying of this e-mail and any attachments thereto or use of their contents by any means whatsoever is strictly prohibited. Unauthorized export or re-export is prohibited.

Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec AMS2759 et AMS 2750.

Le TT a été fait tel que requis par AMS2759 et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec AMS2759 et le bon de commande et le matériel rencontre les exigences spécifiées.

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APPROUVÉ par / Approved by:

Isabel Otero
QA Technician



DATE: 2017-05-17

38
9-88